

December-17-13 9:18:32 AM

110217

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/17/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/17/13 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: PI Date: 3-12-17 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

PL 14-01-8

08/01/2014

PL 14-01-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Picklist Print

December-17-13 9:18:31 AM

Page 1

Work Order ID: 110217
 Parent Item: D3694-041
 Parent Item Name: Mounting Plate

Start Date: 12/17/13 Required Date: 12/17/13
 Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM
 IPP Rev:B 09-01-13 As per Rev C JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R8 Screw		Purchased	No				Each	448.0000		1	FF	07-01-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST346		448							
				9216		448				1			
D3694-1 Mounting Plate		Manufactured	No				Each	6.0000		1	FF	07-01-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST248A		6							
				108991		2				1			
				99144		4							
D3694-3 Mounting Plate Assy		Manufactured	No				Each	8.0000		1	FF	07-01-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST248A		8							
				105385		8				1			
D3694-5 Mounting Plate Assy		Manufactured	No				Each	2.0000		1	FF	07-01-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST247A		2							
				104383		2				1			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

December-17-13 9:18:31 AM

Page 2

Work Order ID: 110217
Parent Item: D3694-041
Parent Item Name: Mounting Plate

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No Each 6,342.0000
Nut

4 FF 07-01-14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	194	
M126333	194	
ST314	28	
M126036	28	
ST506	793	
123900	793	
ST509	4000	
M127304	1000	
M127410	3000	
ST510a	1327	
M126275	8	
M126333	1319	

MS21209-F1-20 Purchased No Each 42.0000
HELI COIL

2 FF 07-01-14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	42	
m127304	42	

MS24693-C271 Purchased No Each 6,634.0000
Screw

1 FF 07-01-14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1166	
1112	1166	
ST310	1183	
1139	1183	
st507	4285	
1112	3664	
1445	383	
1664	238	

December-17-13 9:18:31 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

December-17-13 9:18:31 AM

Page 3

Work Order ID: 110217
Parent Item: D3694-041
Parent Item Name: Mounting Plate

Start Date: 12/17/13
Start Qty: 1.00

Required Date: 12/17/13
Required Qty: 1.00

MS24693-C273
SCREW

Purchased No

Each 105.0000

4 FF 07-01-14

Location

Loc Qty

Loc Code

ST300

105

122539

6

124365

1

m126254

4

m127305

94

4

NAS1149D0363J
Washer

Purchased No

Each 4,179.0000

5 FF 07-01-14

Location

Loc Qty

Loc Code

GA

89

124392

89

ST294

11

113068

11

ST510a

4079

m126319

4079

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

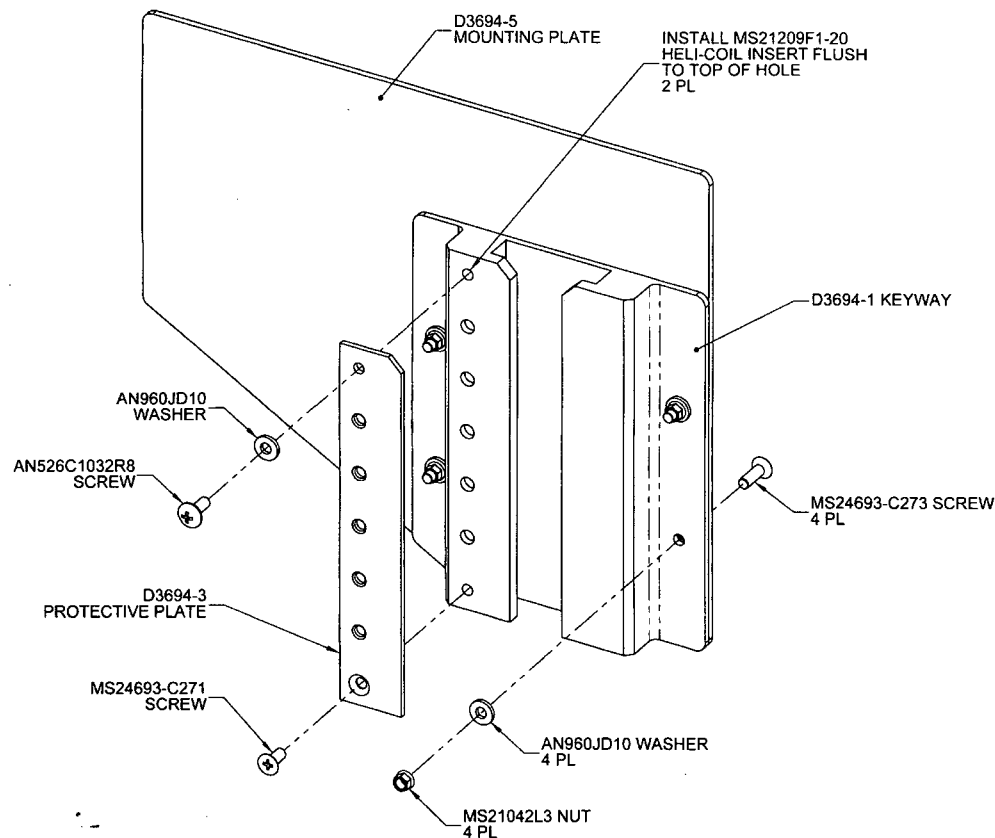
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Training									
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FAULT CATEGORY

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D3694-041 MOUNTING PLATE ASSY

D3694-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

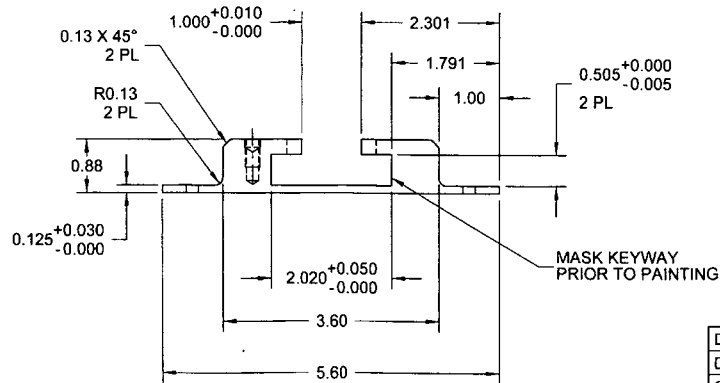
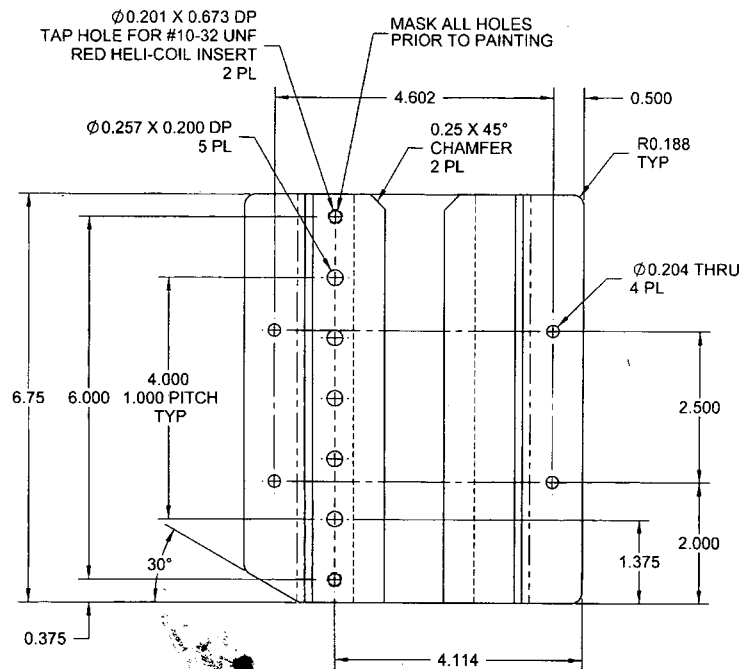
C	REDESIGNED ITEM 11; REVISED ITEM 12: DIM Ø0.204 WAS Ø0.234 (ZN D6-3); ADDED ITEM 13: UPDATED BOM TO CURRENT STANDARDS (ZN D3-1). REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY 1 MS24693-C271 SCREW WAS QTY 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1; ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3). REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.08.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3694	REV. C SHEET 1 OF 4
TITLE MOUNTING PLATE ASSY	SCALE NTS

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110217
RAB-12-18

RELEASED
08/12/05/MB



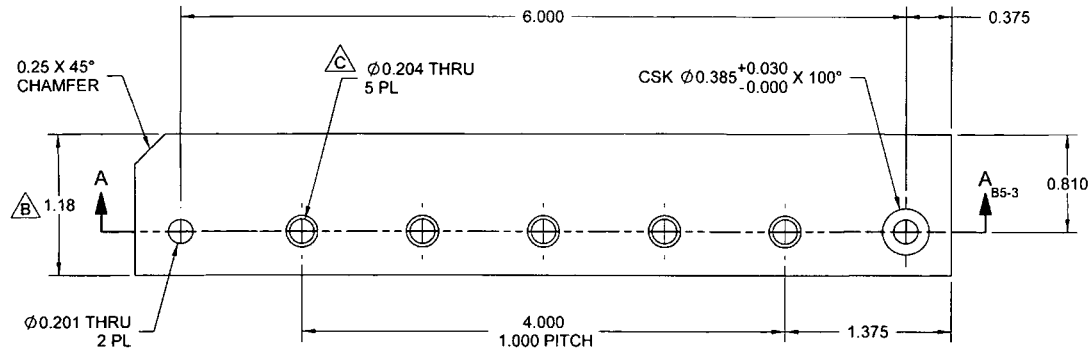
D3694-1 KEYWAY

D3694-1 NOTES:

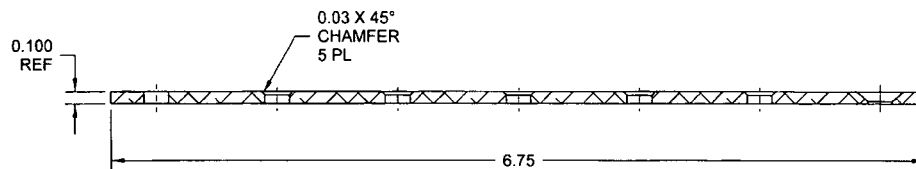
- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

RELEASED
09/04/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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D3694-3 PROTECTIVE PLATE



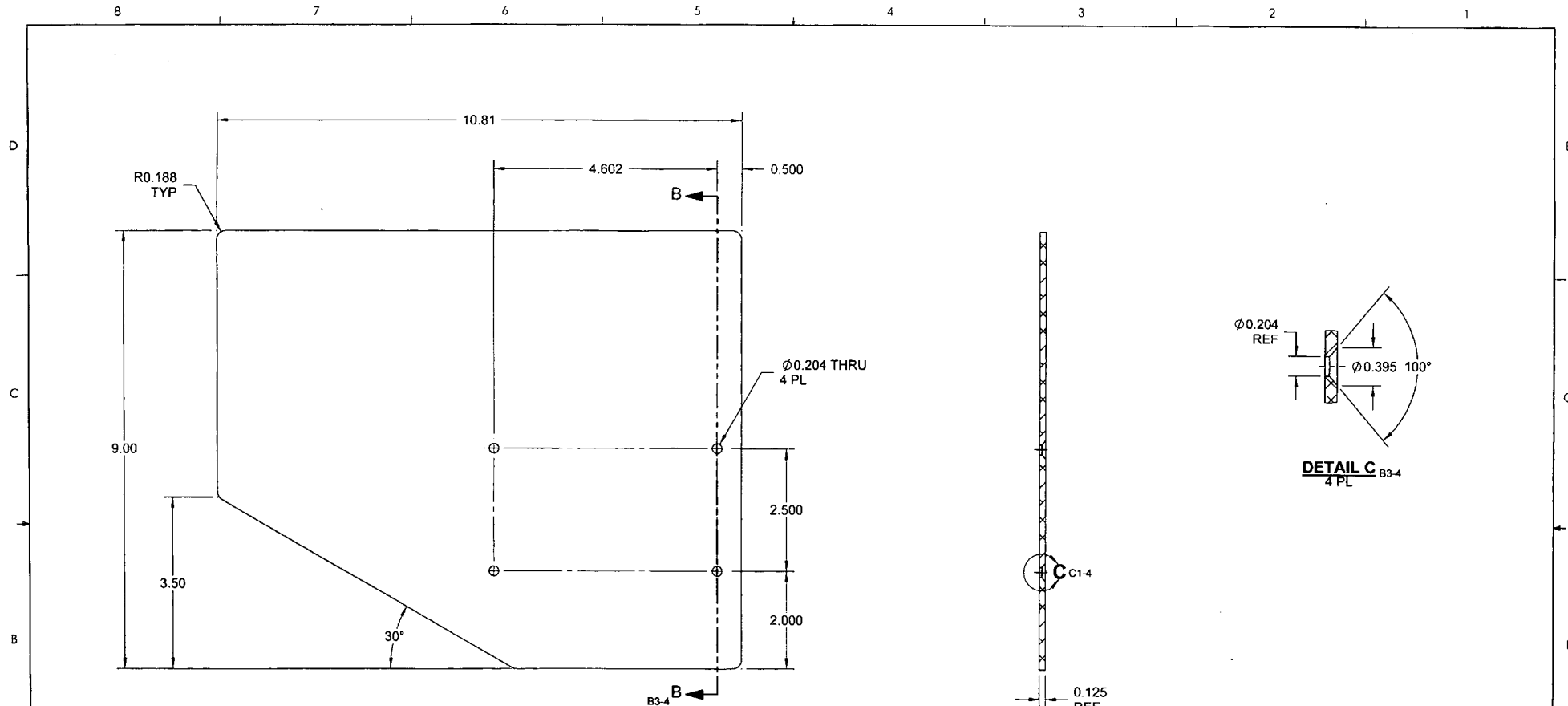
SECTION A-A C3-3

D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),
PER PER AMS 5513 OR AMS 5524
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

RELEASED
9/12/05

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MFG. APPR.		D3694	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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D3694-5 MOUNTING PLATE

SECTION B-B B5-4

RELEASED
6/9/05

D3694-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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